

Work Order ID 53168

October 26, 2009 9:01:51 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *RL*

Date: *27-10-26*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

509/11/18 *HD for BG 09/11/18*

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

① *8209/11/06*

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Item Name: Replacement Skidtube

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
	Skidtubes								
Skidtubes	Memo 1- Deburr ends 2- C'sink holes as per dwg without cutting fluid 3- Prepare tube for welding, remove alodine as required. 4- Scribe batch number insied aft end of tube.	0.00							
130	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							

} BE 09/11/09

DD 09-11-9

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Item ID: D205-634-041

Accept



Setup Start



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Stop



Item Name: Replacement Skidtube

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

mill 999 BE 09/11/09

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill,
A/R□□□ Aluminum Rod

mill 999 BE 09/11/09

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

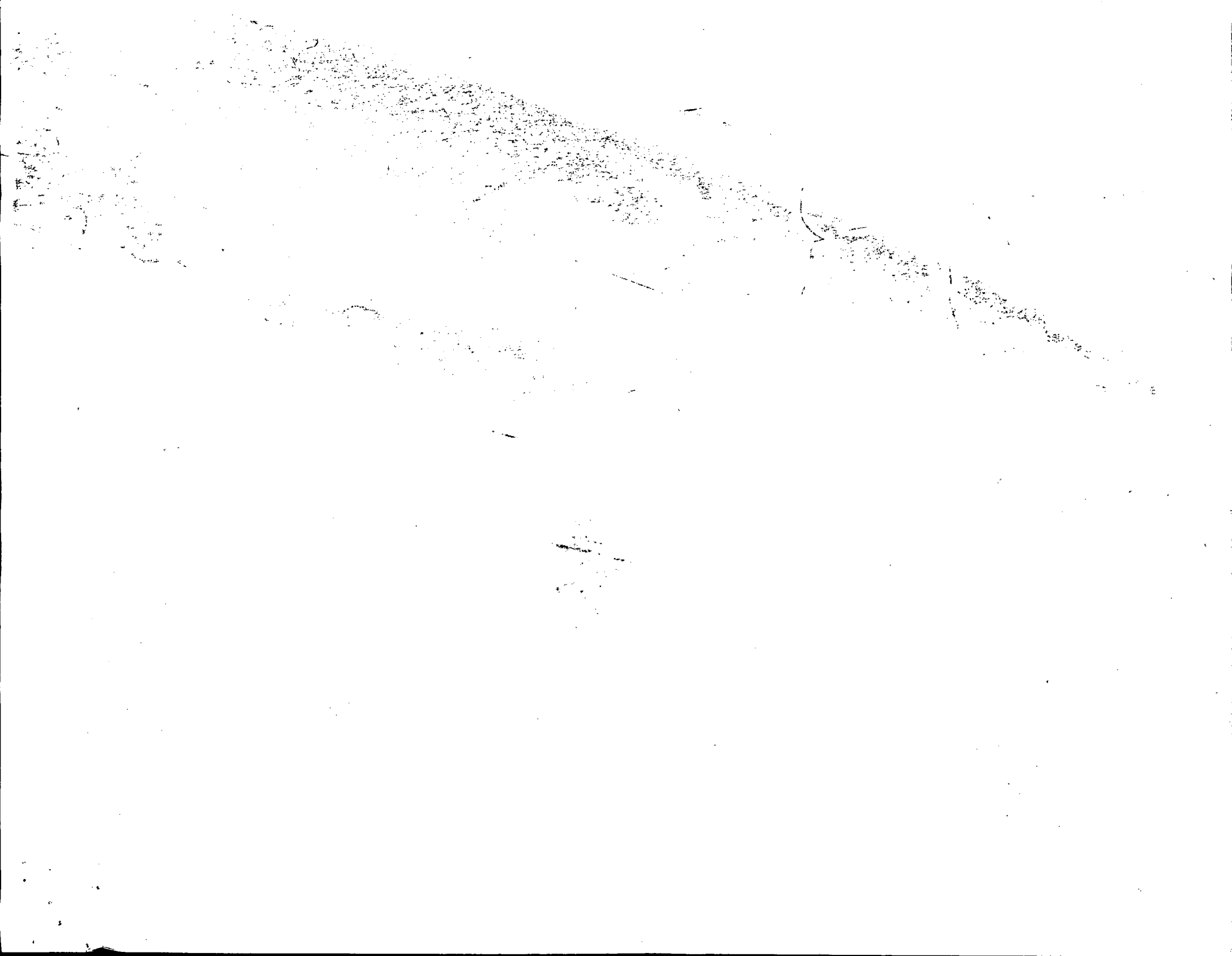
4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Deburr holes

6-Drill pilot holes for air cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Towing using DT8091, open to .640" and Deburr

ARM 9-11-09



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Item ID: D205-634-041

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Revision ID: D

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Item Name: Replacement Skidtube

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				1			
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00	ML	09/11/16		(X1)	Ø		

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Item ID: D205-634-041

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Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M112400

0.00

=> M

09/11/16

(X1)

Ø

Memo

START TIME:

8:15 AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

8:45 AM

0.00

190



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

M 09/11/16

X1

0.00

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Item ID: D205-634-041

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Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ m112391
Sikaflex expire date: 10/20

MO 09/11/17

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ m112391
Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: m112623

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Item ID: D205-634-041

Accept



Setup Start



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Stop



Item Name: Replacement Skidtube

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

278026/11/17

0.00

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024



f

220



Packaging

Packaging

Packaging

0.00

0.00

Memo

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: D

Lo 9/11/18 0

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

09/11/19 19

u 09.11.18

Picklist Print

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Page 1

Work Order ID: 53168

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube



Comments:

Start Date: 26/10/2009

Required Date: 10/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD 		Manufactured	No			110	Each	0.0000	1.0000		DD 9-11-09	
205 Skidtube bent detail												
D2576-3RevG 		Manufactured	No			140	Each	169.0000	1.0000			
Step (maching detail)												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	169
43504	21
46661	101
52215	47

140 Each 695.0000 20.0000

D2579RevE



Crossbolt Spacer

Manufactured No

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG	573
51525	573

Main Warehouse

ST	122
43988	4
46434	4
46956	2
47797	9
48272	2
51314	71
51315	30

1 DE 09-11-09

20 DE 09-11-09

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Work Order ID: 53168

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube



Comments:

Start Date: 26/10/2009

Required Date: 10/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2855RevA		Manufactured	No			200	Each	106.0000	1.0000			
												
Cap												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP6

106

50513

1

50770

5

51539

100

AN3-5A

Purchased

No

200

Each

2,249.000 2.0000



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2249

100188

188

105057

2061

~~XT~~ MD 09/11/16

~~XT~~ MD 09/11/16

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Work Order ID: 53168

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube



Comments:

Start Date: 26/10/2009

Required Date: 10/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L 		Purchased	No			200	Each	5,949.000	2.0000			
Washer												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	5949	
101291	16	
104885	153	
105793	236	
109632	544	
110985	5000	

X2 MD 09/11/16

ALS7-1032-130

Purchased

No

200

Each

2,234.000 50.0000



Insert

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	2234	
105855	16	
108606	52	
111529	1488	
111779	313	
112772	365	

410511

X50 MD 09/11/16

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Work Order ID: 53168



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3C4A Purchased No 200 Each 1,474.000 50.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1474	
112314	13	
112720	12	
112724	3	
112794	846	
112829	500	
112991	100	

XSO MD 09/11/10

AN960C10L Purchased No 200 Each 4,868.000 50.0000



washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	4768	
112116	876	
112612	2892	
112933	1000	

XSO MD 09/11/10

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Work Order ID: 53168



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-13RevC		Manufactured	No			200	Each	33.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	31	
51606	31	
Main Warehouse		
ST	2	
45717	1	
50265	1	

21 1009/11/16

Picklist Print

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Work Order ID: 53168



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-5RevC		Manufactured	No			200	Each	37.0000	1.0000			
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	12	
51929	12	
Main Warehouse		
FP19	21	
51669	1	
52909	20	
Main Warehouse		
ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

X1 mps 09/11/16

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Work Order ID: 53168



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-1RevC		Manufactured	No			200	Each	26.0000	2.0000			

Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

21

52512

21

Main Warehouse

ST

5

46349

1

51218

1

51259

3

Handwritten: 22 MD09/11/16

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Work Order ID: 53168



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-11RevD		Manufactured	No			200	Each	46.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	11	
51905	11	
Main Warehouse		
FP19	33	
51594	10	
52125	23	
Main Warehouse		
ST	2	
45823	1	
50112	1	

XI MD 09/11/16

Picklist Print

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Work Order ID: 53168



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-13RevD		Manufactured	No			200	Each	56.0000	1.0000			
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP17	44	
51611	33	
52059	11	
Main Warehouse		
ST	12	
45409	2	
46495	10	

XI MD 09/11/16

D3564-9RevD

Manufactured No

200

Each

10.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP19	8	
51675	8	
Main Warehouse		
ST	2	
44659	1	
45825	1	

XI MD 09/11/16

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Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-5RevD		Manufactured	No			200	Each	37.0000	1.0000			
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	18	
51655	10	
51925	8	
Main Warehouse		
ST	17	
45824	1	
47433	1	
52595	15	

XT MD 09/11/16

D2594-3RevC

Manufactured No

200

Each

1,050.000 16.0000



O-Ring, 205 Skidtube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	50	
51613	50	
Main Warehouse		
ST	1000	
52562	1000	

XT MD 09/11/16

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Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-1RevC		Manufactured	No			200	Each	601.0000	16.0000			
Plug, 205 Skidtube												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

601

42221

16

42807

92

43884

3

46435

2

51527

9

51757

479

116 MD 09/11/16

DART**RELEASED**
07-06-28 #

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53168

07-10-26

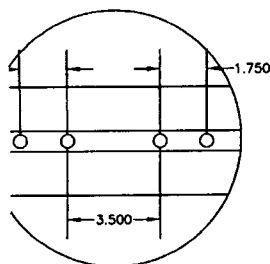
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

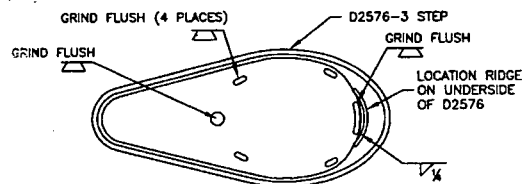
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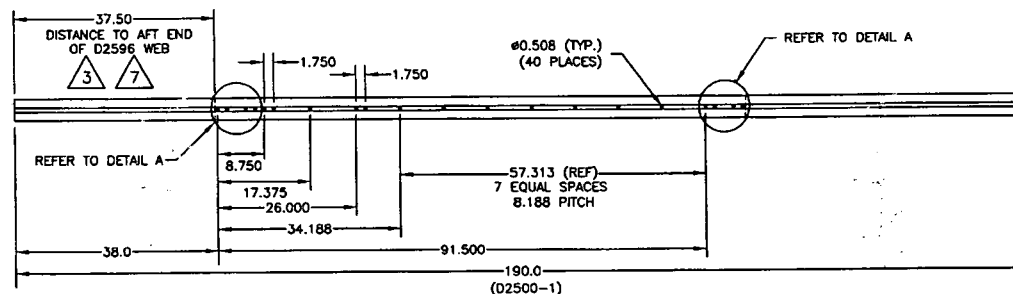
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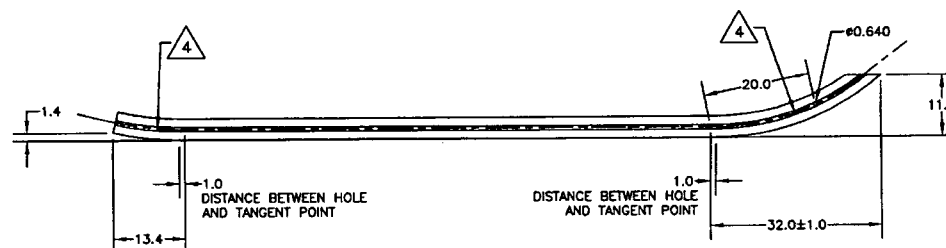
DETAIL B
SCALE 5:24



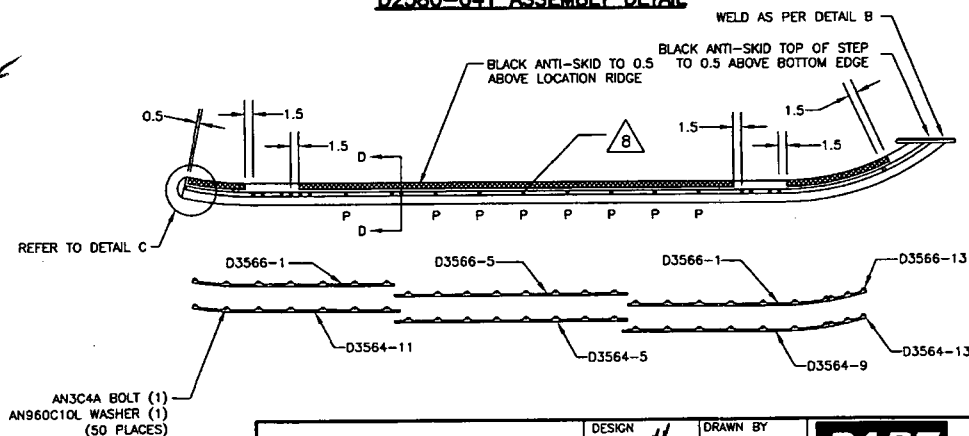
D2580-1 DRILLING DETAIL



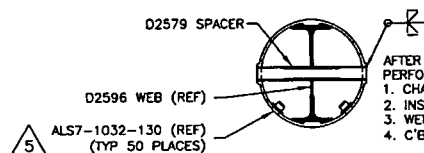
D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



SECTION D-D
SCALE 5:24



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

-041 NOTES

INISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

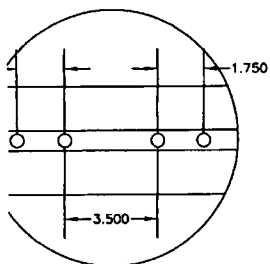
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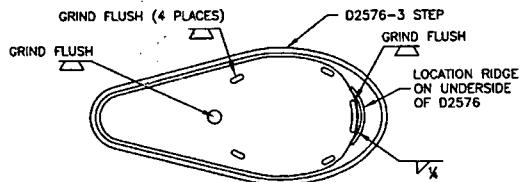
DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>
DATE			
07.02.27			

DART		DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA	
DRAWING NO. D2580		REV. D SHEET 2 OF 3	
TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24	

DETAIL E SCALE 5:24

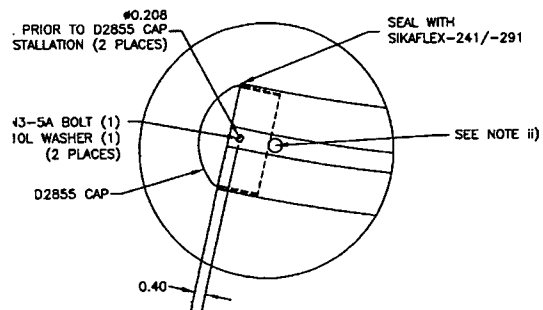


DETAIL F SCALE 5:24

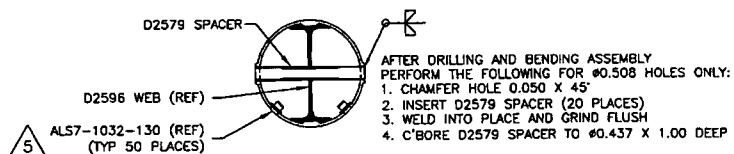


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07.06.28

DETAIL G SCALE 5:24

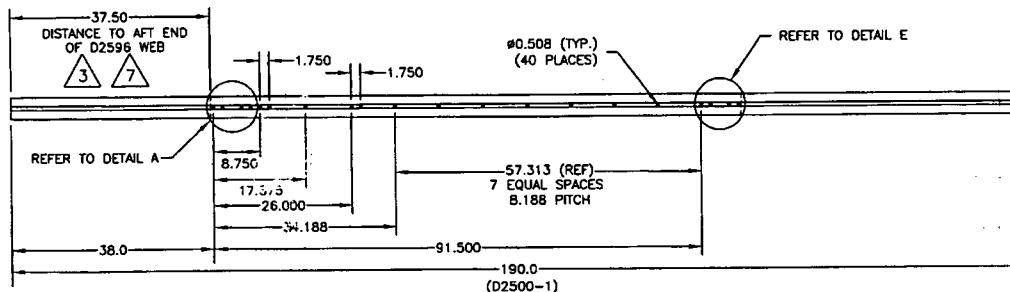


SECTION H-H SCALE 5:24

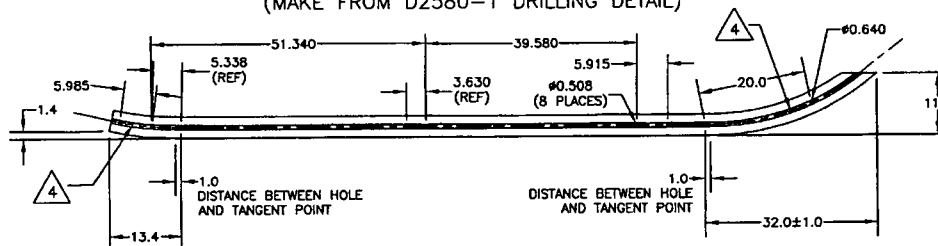


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

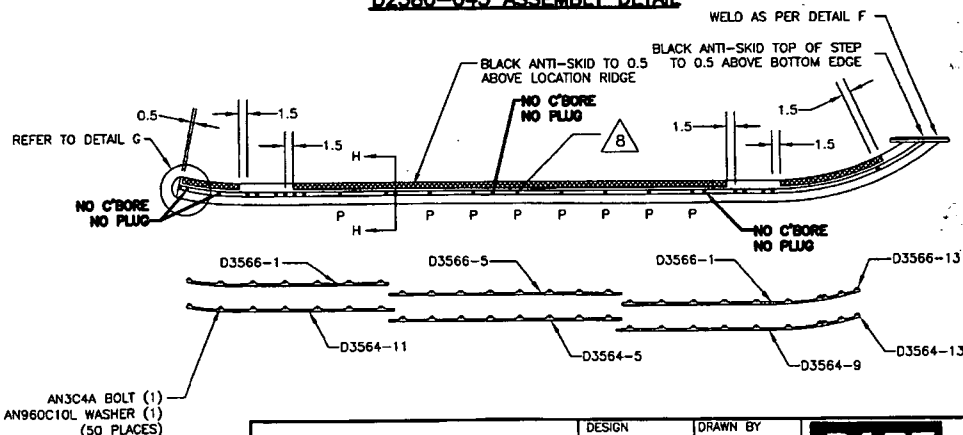
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL (MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



-045 NOTES

INISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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CHECKED H	APPROVED H	DRAWING NO. D2580	REV. D
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SHEET 3 OF 3
		SCALE 1:24	